

Work Order ID 67012

Thursday, March 03, 2011 11:49:26 AM



Page 1

Item ID: D3594-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Doubler Assembly, LH

Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3594	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3594 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 11-3-9

(15)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-3-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 11/03/09

(15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

C'SINK AS PER DWG D3594

4511/03/09 (15)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sub 03/09

(45)

3

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

15 BL/A.E 11-3-11

W/O:		WORK ORDER CHANGES					
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Thursday, March 03, 2011 11:49:26 AM



Page 3

Item ID: D3594-043	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Floor Doubler Assembly, LH					
Start Date: 3/3/2011	Start Qty: 12.00		Cust Item ID:		
Required Date: 3/7/2011	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 Small Fab Small Fab	Small Fab Memo Install Nut Plates As per Dwg D3594	0.00 0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

15 0 11/10/03/14

JS 4/04/25 (15)

8 11/14/25

(15)
243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Item Name: Floor Doubler Assembly, LH

Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location

234B

0.00



Packaging

Memo

0.00

Packaging

11/4/25 SL 150

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/26 J

MF
11-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 11:49:36 AM

Page 1

Work Order ID: 67012

Parent Item: D3594-043

Parent Item Name: Floor Doubler Assembly, LH

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD4-4 Purchased No



Rivet

Location

Loc Qty

Loc Code

ST316

19

15541

19

ST317

2993

116188

2993

170

sf

235.7000

0.51

6.442105

M6061T6S:080

Purchased

No



6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT

235.7

116268

52.6

116700

183.1

170

Each

8.0000

1

MS21069-5

Purchased

No



Anchor nuts

Location

Loc Qty

Loc Code

ST302

8

113725

4

116635

4

M117504
(15x)

24
3/4/25

30
16
B1-3-9

116706
12
3/4/25

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>67012</i>
Description: Floor Doubler, LH		Part Number:	D3594-3
Inspection Dwg: D3594 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	12.25	✓		T HB01	
7.85	+/-0.030	7.845	✗		PROW502	
7.313	+/-0.010	7.316	✗		PROW502	
2.688	+/-0.010	2.686	✗		V HB02	
Ø0.323	+0.006/-0.001	.325	✓		✓	
Ø0.128	+0.005/-0.001	.132	✗		✓	
0.359	+/-0.010	.357	✗		✓	
0.718	+/-0.010	.718	✗		✓	
0.81	+/-0.030	.812	✓		✓	
2.32	+/-0.030	2.32	✗		✓	
0.080	+/-0.010	.078	✗		✓	

Measured by: <i>RB</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>11-3-9</i>	Date: <i>11/03/09</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-043	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	
C	09.05.07	Dimensions updated per Dwg Rev B	KJ/EC	<i>[Signature]</i>

Dart Aerospace Ltd

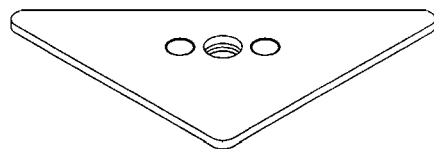
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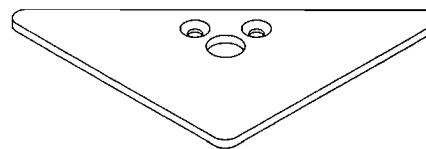
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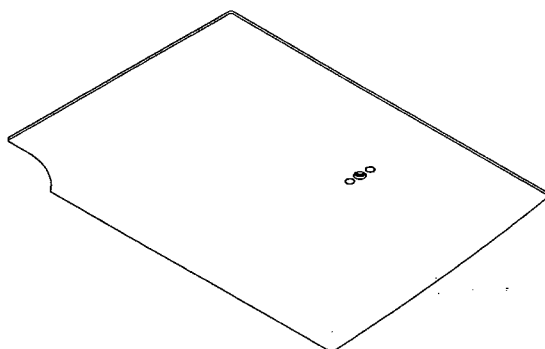


D3594-041 DOOR DOUBLER ASSEMBLY

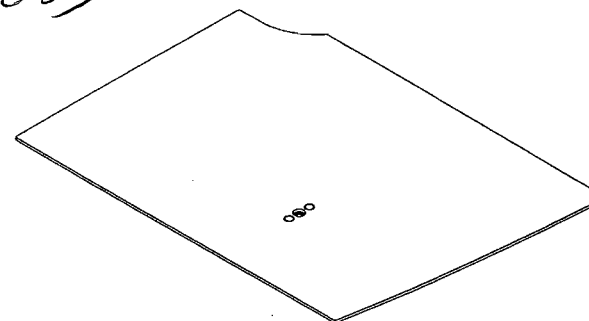


D3594-5 DOOR DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67012
PL11-03-3



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

RELEASED
08.05.14

B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3594 REV. B SHEET 1 OF 4 TITLE DOUBLER SCALE NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

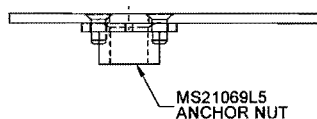
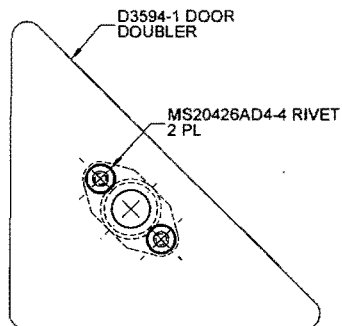
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

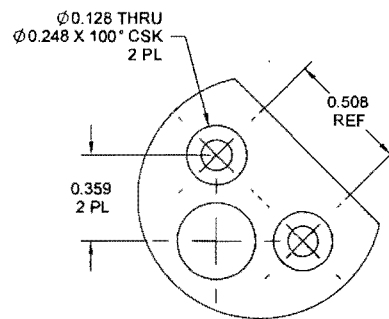
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

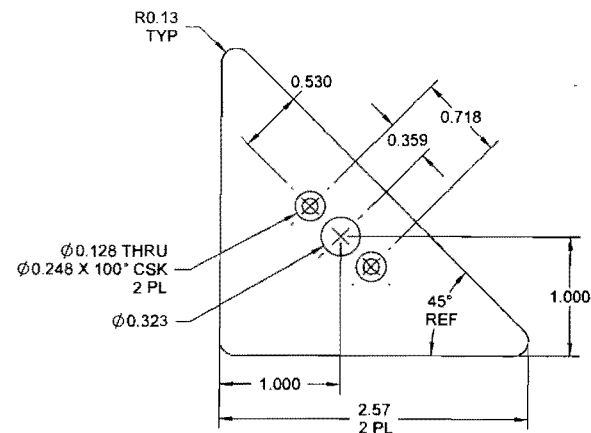
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



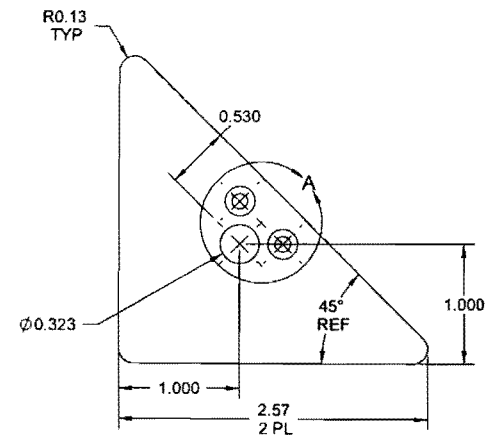
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER

NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.D80)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

also 67012

RELEASED
28 DEC 2014

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED		DRAWING NO. D3594	REV. B
MFG. APPR.		TITLE DOUBLER	SHEET 2 OF 4
APPROVED			SCALE NTS
DE APPR.		DATE 08.05.14	

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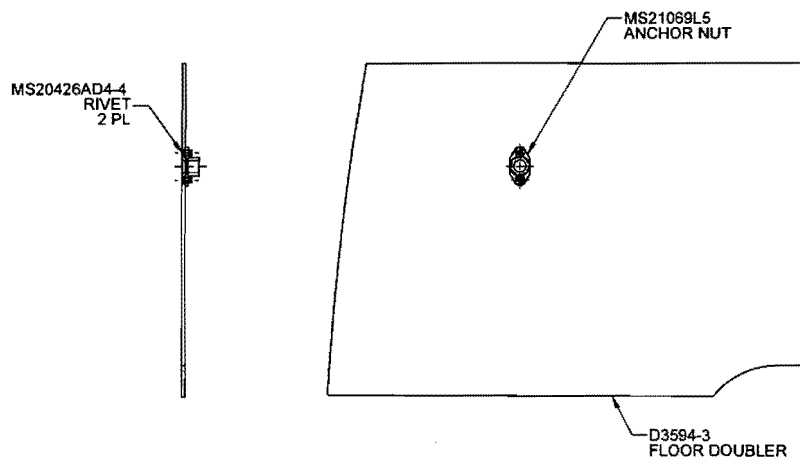
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

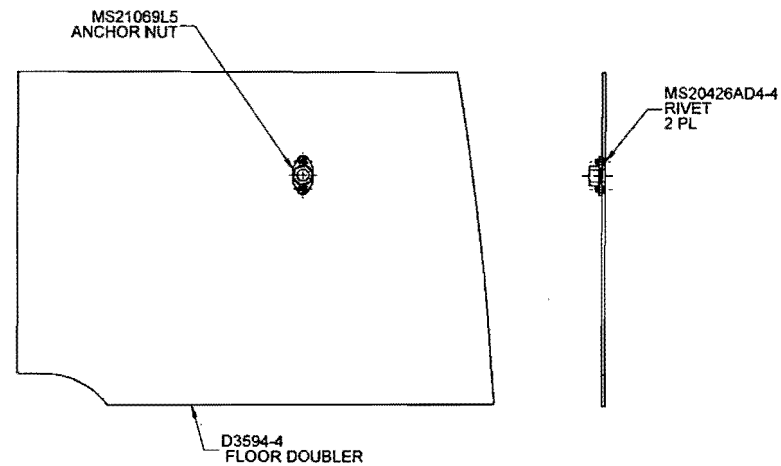
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NOTE: Date & initial all entries

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

also 62012

RELEASED
11/06/2014

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	08.05.14	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

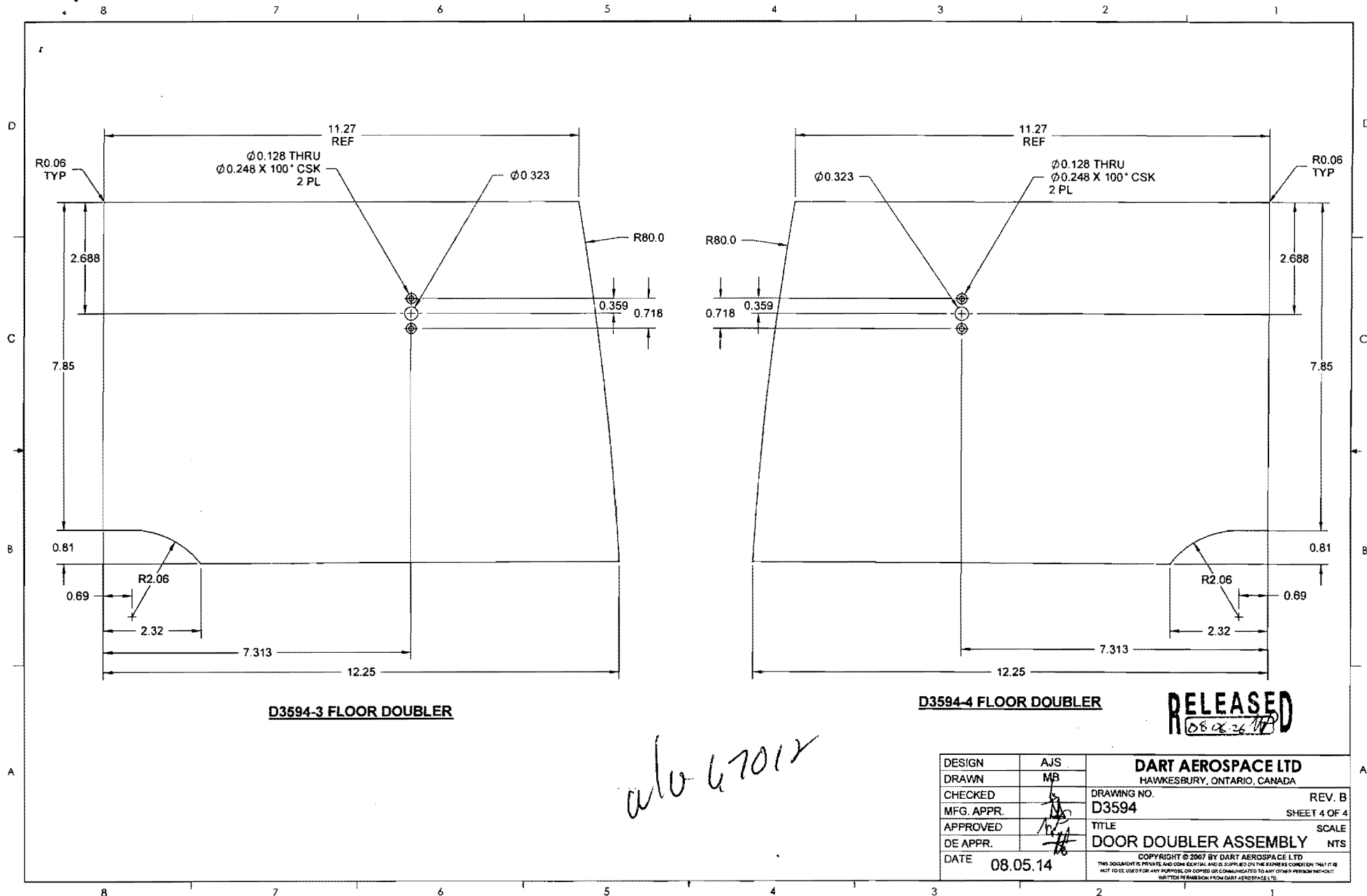
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3594	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE DOOR DOUBLER ASSEMBLY	SCALE NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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08.05.14

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